

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019437**Date Inspected:** 12-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Shi Lei (east) Bao Lei Zhang (west)			<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No N/A
				<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG	

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Kenneth Riley was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Magnetic Particle Witness; 8AW-8BW / Trial Assembly

This Caltrans QA inspector received nondestructive test (NDT) notification; ABF Verification Witness Request, document number 06122010-1, This Caltrans QA inspector witnessed ABF personnel performing Magnetic Particle (MT) inspection at the following locations;

Item number 2, OBW8A-003, BP-D6 no rejectable linear indications were noted.

Item number 3, SEG043-044, DP to EP-W5 Holdback @ 8AW-8BW, no rejectable linear indications were noted.

This Caltrans QA inspector received NDT notification; ABF Verification Witness Request, document number 06122010-2, This Caltrans QA inspector witnessed ABF personnel performing Magnetic Particle (MT) inspection at the following locations;

Item number 1, OBW8A-001,002 SP-C4, C5- 1 rejectable linear indication was noted at Y=5500 on weld OBW8B-002, C5.

Item number 2, OBW8A-003 BP-D6 no rejectable linear indications were noted.

Item number 3, SEG043-044 BP to SP-W4 (CB Side) no rejectable linear indications were noted.

Item number 4, OBW8C-004-SP-E7 (CB Side) no rejectable linear indications were noted.

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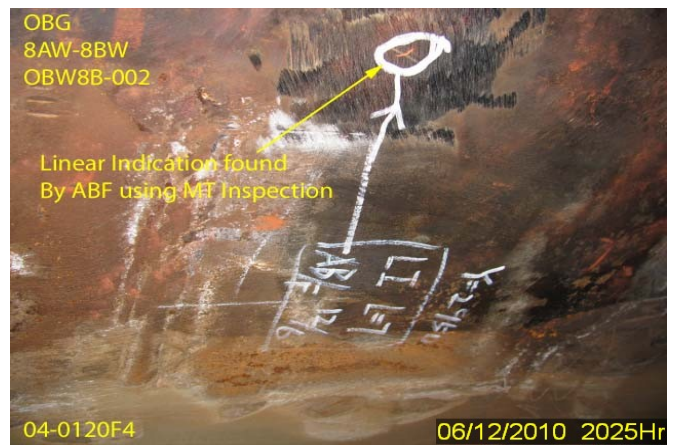
## WELDING INSPECTION REPORT

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### Ultrasonic Testing; 8AW-8BW / Trial Assembly

This Caltrans QA inspector received nondestructive test (NDT) notification; ABF Verification Witness Request, document number 06122010-2; Item #1; ABF UT Report #UT-8W-029-R2, weld number OBW8A-002, weld C5. . ABF UT Report #UT-8W-029-R1, weld number OBW8B-002, weld C4. Item #2; ABF UT Report #UT-8W-028-R2, weld number OBW8A-003, weld D6. Item #3; ABF UT Report #UT-8W-027-R3, weld number BP to SP-W4(SEG 043A-021) .This Caltrans QA inspector performed UT inspection using the conventional scan pattern A, B, C, E and D on previously inspected weld. This QA inspector concurs with ABF evaluation, acceptance and/or rejection of the weld repairs. QA MT was not performed, due to the surface condition of the plate having coupling on it from previous UT inspection by ABF. See Caltrans Ultrasonic Test Report (TL6027), date 06-12-2010 for additional information.



### Summary of Conversations:

No Conversations This date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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